

Work Order ID 131770

Tuesday, April 21, 2015 1:49:46 PM

131770

Page 1

Item ID: D3571-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Guide

Start Date: 4/20/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan: ML5 Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3571	Rev A

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 2.90 " long								

DAS 40 15-5-6 15/05/04

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA675 Rev: <u>AA</u> & Dwg D3571 Rev: <u>A</u> 2-Deburr per dwg D3571								

DAS 40 15-5-6 15/05/04

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 40 15-5-6 15/05/04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 9 9-89 DAS 14 9-89
130						19			1505/09
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						19	Ø	15-5-15	JK
HandFinish	Memo	0.00							
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 1:35 FINISH TIME: 2:05 OVEN TEMPERATURE:								

R.T.O.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																											
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131770

Page 3

Item ID: D3571-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Guide

Start Date: 4/20/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

050
ST051A

(18)

DAS
38
9-89
MAY 22 2015

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

18

MAY 25 2015

DAS
26
9-89

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ

MAY 26 2015

MLJ

MAY 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Tuesday, April 21, 2015 1:49:45 PM

Page 1

Work Order ID: 131770

131770

Parent Item: D3571-1

D3571-1

Parent Item Name: Guide

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased			No	100	f	26.1419	0.241	4			

M6061T6B0 750X01 500

6061-T6 Bar .750 X 1.50

15/08/04

DAS
40
9-89

Location

Loc Qty

Loc Code

MAT

26.1418948

→ m131226

2.1418948

→ m131700

24

2 1418948
141.7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 131770
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.690	✓		VERW	PHD-12
Ø1.00 Depth 100	+/-0.010	.995 _{x.100}	✓		"	"
2.75	+/-0.030	2.752	✓		"	"
1.38	+/-0.030	1.370	✓		"	"
1.25	+/-0.030	1.246	✓		"	"
0.63	+/-0.010	.621	✓		"	"
0.031 chamfer	+/-0.010	.028	✓		"	"
Ø0.500	+0.006/-0.001	.501	✓		"	"
Ø0.201	+0.005/-0.001	.203	✓		"	"
R0.25	+/-0.030	.250	✓		Rad C	
0.260	+0.000/-0.010	.260	✓		VERW	PHD-12
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	.385	✓		"	"
0.125	+/-0.010	.134	✓		"	"
2.250	+/-0.010	2.243	✓		"	"
0.250	+/-0.010	.254	✓		"	"
0.188	+/-0.010	.180	✓		"	"
0.063 chamfer	+/-0.010	.060	✓		"	"

DAS

40

9-89

Measured by:	DAS 40 9-89
Date:	15/05/04

Audited by:	DAS 9 14 9-89 9-89
Date:	15-05-08

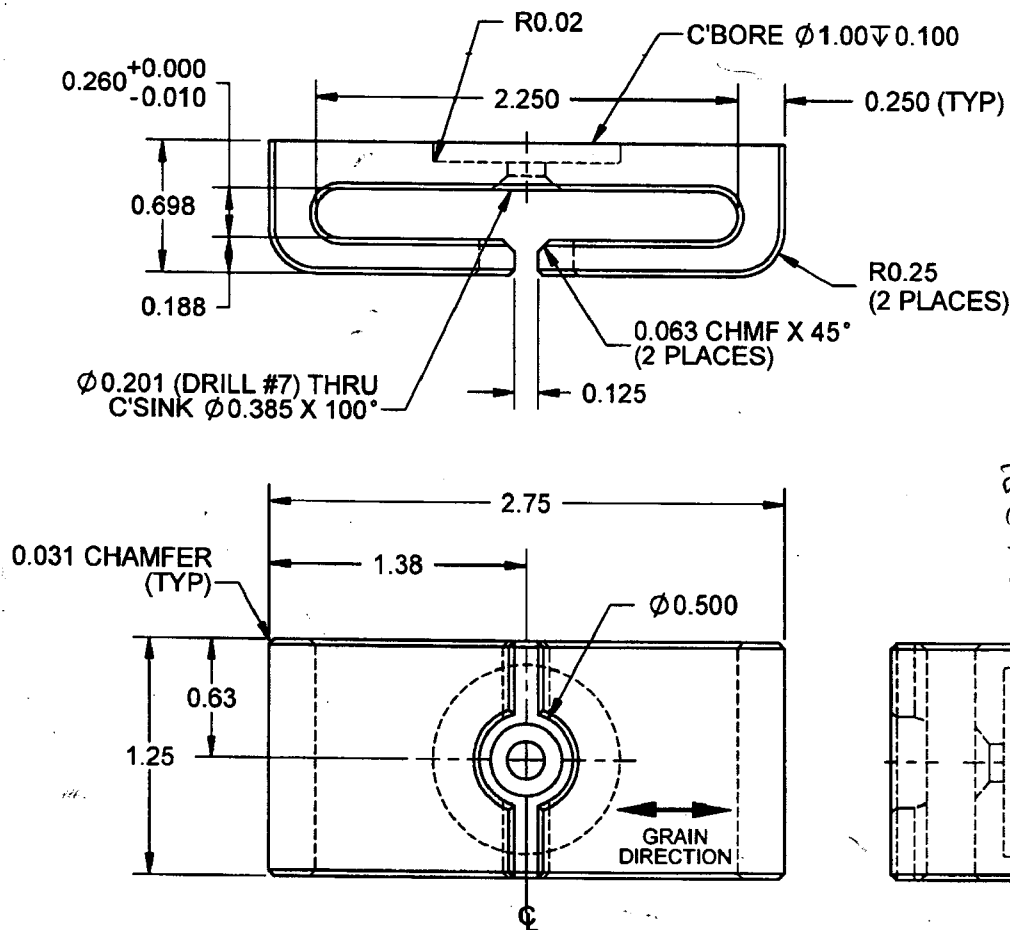
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED
07.04.12 *[Signature]*



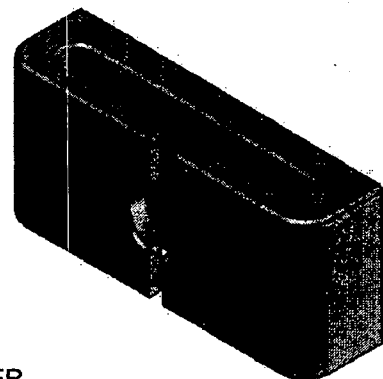
D3571-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

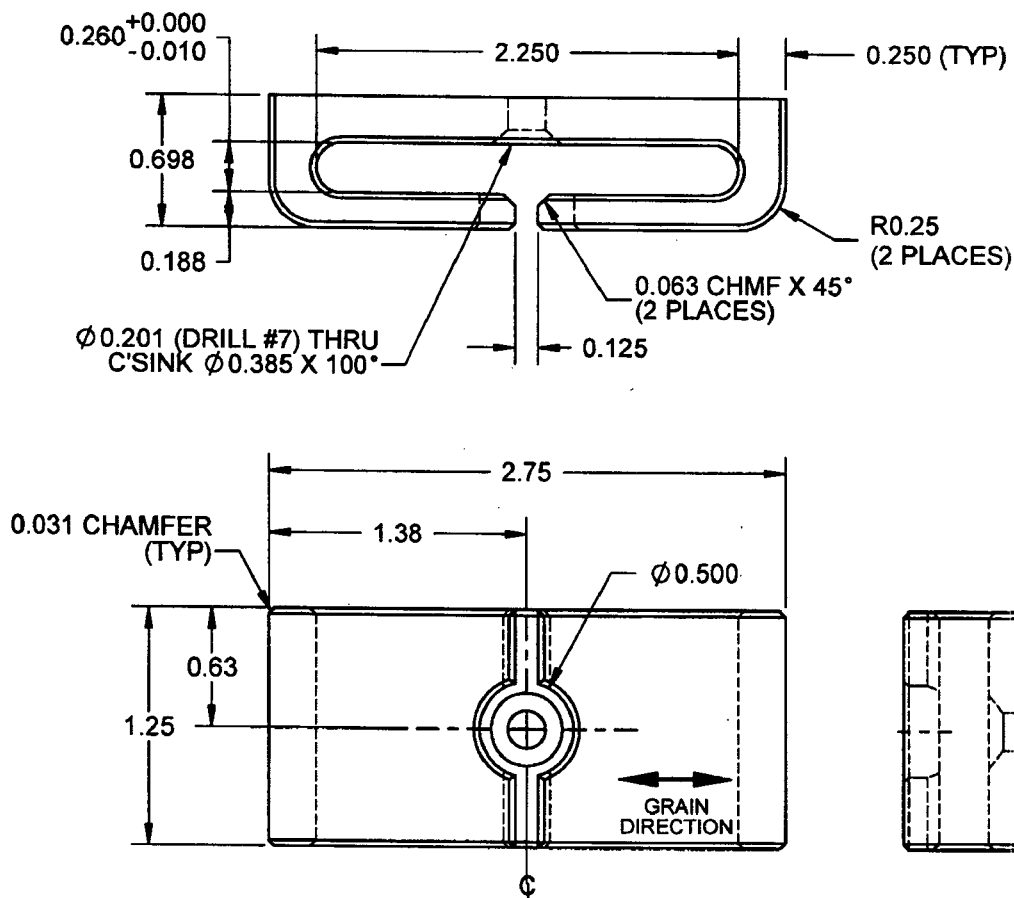
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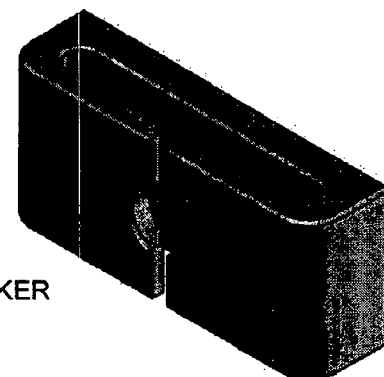


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DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED07.01.12 *[Signature]***D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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